

machining the previously cold-headed one end portion to form a cam engaging portion of said wear resistant shoe; and

subsequently cold-working and thereby hardening the opposite end portion.

4. (Amended) The method of claim 3, wherein the step of machining the one end portion machines the one end portion to predetermined final dimensions subsequent to the step of cold-heading and prior to the step of crimping.

5. (Amended) The method of claim 3, wherein the step of machining the cold-headed end portion forms a cam engaging wear resistant surface.

10. (Amended) A method of manufacturing a wear resistant shoe, comprising:  
work hardening a portion of a cylindrical member to a substantial depth;  
machining the work-hardened cylindrical member portion to finished dimensions, thereby forming a cam engaging portion of said wear resistant shoe; and  
surface hardening a face of the machined cylindrical member portion.

15. (Amended) A method of forming and assembling a piston and wear resistant shoe, the shoe formed from rod stock of a diameter less than the greatest diameter of the finished shoe, comprising:

upsetting one end portion of the rod stock to axially reduce and radially increase the dimensions of the one end portion;

machining the previously upset one end portion to form a cam engaging portion of said wear resistant shoe;

forming a hollow region in an opposite rod stock end portion; and

94 crimping the periphery of the hollow region about a rounded end of the piston rod.

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95 19. (Amended) A method of forming and assembling a piston and wear resistant shoe, the shoe formed from hardened rod stock, comprising:

machining a region of the hardened rod stock to form a cam engaging wear resistant surface of the wear resistant shoe;

forming a hollow region in one rod stock end portion;

annealing the one end portion of the rod stock; and

crimping the periphery of the hollow region about a rounded end of the piston rod.

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96 21. (Amended) The method of claim 19, further including the step of surface hardening the machined cam engaging surface.

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